

Date: Tuesday, 29/07/2008 1:51:39 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER TUBE
Job Number	: 40778		
Estimate Number	: 13499		
P.O. Number	:	Part Number	: PB6743001197
This Issue	: 29/07/2008 S.O. No. :	Drawing Number	: B6743001 P.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 05/08/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>Wmf 08-07-29</u>		
Comment	: Est Rev:A 08-07-24 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1750W065	6061T6 RDTUBE 1.750 X 0.65W
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Comment: Qty.: 4.3864 f(s)/Unit Total: 21.9319 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: m18489=4 m18188=1

08-07-29 5

2.0	BAND SAW	BAND SAW
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2-cut a 27 degree angle on one end of tube as per dwg

2- deburr

08-07-29 5

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001

2- deburr

See Last Page  
08/7/30

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/7/30

5.0	PB6743001199	Outer Tube End Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Outer Tube End Cap

batch: 40032 08-07-30

5x

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Drawing Name: OUTER TUBE

Job Number: 40778

Part Number: PB6743001197

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld end cap as per dwg PB6743001

2-grind end cap flush

*Handwritten: 08-07-30*

*Handwritten: (5x)*

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*Handwritten: 08/7/30*

*Handwritten: (48)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten: 08/7/30*

*Handwritten: (40)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*Handwritten: 08-07-31 5*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten: 08/05/08*

Job Completion



*Handwritten: 08/08/01*

ORIGINAL

PREMIER AVIATION, INC.		3000 Aviation Parkway, Grand Prairie, Texas 75052	
DATE CODE: 10/07 RD.	DRG NO	0 OSUV8	867-43001
REV		REV	
REV		REV	

④  
-207 SQUARE TUBE  
MATT: 1.00 SO X .125 WALL, 6061-T6  
CO-A-200/8  
SCAL: 0.500

Technical drawing of a vertical plate with dimensions and labels. The drawing shows a vertical plate with a total height of 22.25. The plate has a thickness of 1.75. There are four circular features (holes) along the right edge, each labeled  $\phi .50$  THRU. The distance between the centers of the two upper holes is 6.75. The distance between the centers of the two lower holes is 5.75. The distance from the bottom edge to the center of the lower hole is 1.75. The distance from the top edge to the center of the upper hole is 1.75. The drawing is oriented vertically, with the top edge on the left and the bottom edge on the right.

201 SQUARE TUBE  
DATE: 1 06 SC X 065 MAIL, 6661-16  
00-A-200/8  
SCALE: 0.500

19.25

①  
-205 OUTER TUBE  
MALL: 1.75 OD X .065 WALL, 6061-T6  
HW-1-760/6  
SCALE 0.250

① -1.97 OUTER TUBE  
MATT: 1.75 OD X .665 WALL, 5061-16  
WM-1-700/6  
SCALE 0.250

RELEASED  
JUL 26 1964

DART AEROSPACE LTD		Work Order:	
Description: <i>Center Tank</i>		Part Number:	<i>BE7-43001-197</i>
Dwg: <i>BE7-43001 Rev B</i>		Qty:	
		Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	MM	Apply <i>Welding</i> cap. Dry BE7-43001			
		Mat 6061-T6 1.75" x 0.0625" x 11	JL	08/07/14	5
		Welding Etch: <i>m18489=4</i> <i>m18188=1</i>			
3	DC	Inspect parts as they come off the machine	JL	08/07/14	5
4	DC	Load Check	J.F	08/07/14	005
5	MM	Submer	JL	08/07/14	5
6	SI	Identify: Steel			
7	CK	Cost/Part			
8	DC	Close up/Load st.			
REFERENCE ONLY					

Rev	Date	Change	Revised By	Approved
				<i>[Signature]</i>

**PRELIMINARY ISSUE**